

Work Order ID 149206

July 21, 2016 3:21:52 PM

149206

Page 1

Item ID: D2807-041

Revision ID:

Item Name: Prop Assembly

Start Date: 9/26/2016 Start Qty: 105.00

Required Date: 9/30/2016 Req'd Qty: 105.00

Reference:

Accept

N9000040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2807	Rev E

100 PURCHASING 0.00

100

Purchasing

Memo 33130 0.00

Issue P/O: 33130 Order as per Dwg D2807 Possible

supplier: Lift Support Technologies, Saskatoon, Canada P/N 6/15-164/50-115N

Material release note is required

W 16.07.22

110 Receive & Inspect for Damage & Mat'l Certs 0.00

110

Packaging

Memo 0.35

Packaging Ensure Material Release Note is attached

30 DAS 6 9-89 AUG 25 2016

120 QC6- Inspect dimensions to drawing 0.00

120

QC

Memo 0.00

Quality Control

(30) DAS 38 9-89 AUG 25 2016

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Item ID: D2807-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Prop Assembly
 Start Date: 9/26/2016 Start Qty: 105.00 ***105*** Cust Item ID:
 Required Date: 9/30/2016 Req'd Qty: 105.00 ***105*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab	Small Fab	0.00				30x			16/08/29
Small Fab	Memo	0.35							
Small Fab	1-install D3671-1 as per dwg D2807								
140 *140* QC	QC5- Inspect part completeness to step on W/O	0.00				30			
Quality Control	Memo	0.35							AUG 29 2016
150 *150* Packaging	Identify as per dwg & Stock Location: 5404	0.00				30			
Packaging	Memo	0.17							AUG 30 2016

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Item ID: D2807-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Prop Assembly
 Start Date: 9/26/2016 Start Qty: 105.00 ***105*** Cust Item ID:
 Required Date: 9/30/2016 Req'd Qty: 105.00 ***105*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00					DAS 21 9-89		AUG 3 1 2016
160									
QC	Memo	1.75							
Quality Control									

THE
 16-8-36

Picklist Print

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Work Order ID: 149206

149206

Parent Item: D2807-041

D2807-041

Parent Item Name: Prop Assembly

Start Date: 9/26/2016

Required Date: 9/30/2016

Start Qty: 105.00

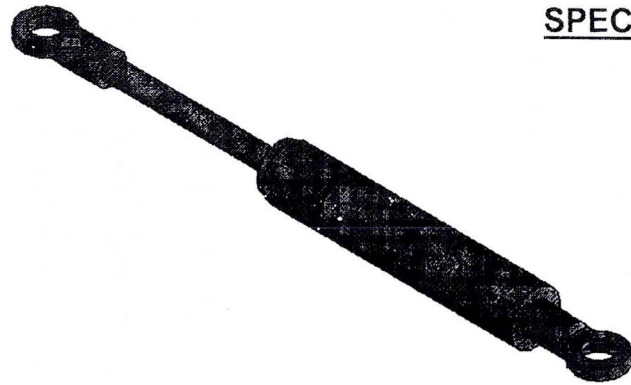
Required Qty: 105.00

Comments: IPP: D 07.11.12 ecn1019, replaces D2807 ECverified by DD
IPP Rev:E 08-02-12 ECN 1111 DD verified by: ec

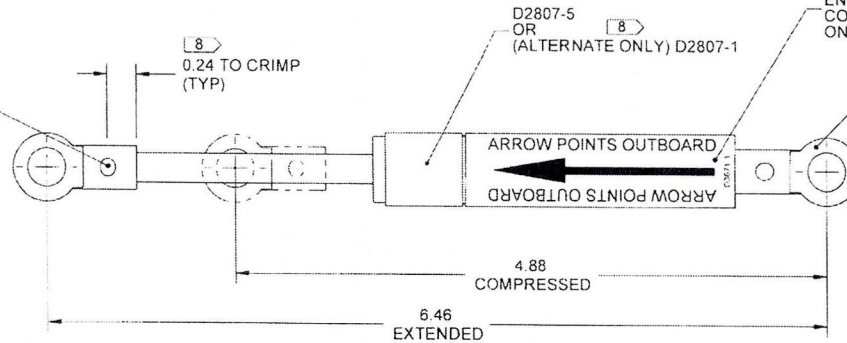
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3671-1		Manufactured	No			110	Each	5.0000	1	105			
D3671-1									**				
Placard													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				GA				5					
					143810			5					
6/15-164/50-115N		Purchased	No			130	Each	0.0000	1	105			
6/15-164/50-115N									**				
Gas Spring													

16/08/29 36 9-89
B149002 (3x)
B149360 (27x)
SL

SPECIFICATION CONTROL DRAWING



(ALTERNATE ONLY)
CRIMP 0.015-0.025 DEEP
WITH $\varnothing 0.375$ TOOL AT
2000psi (REF), TYP TWO
SIDES PER LUG



AFFIX D3671-1 PLACARD
ENSURE PLACARD DOES NOT
CONCEAL ANY TEXT OR MARKINGS
ON THE GAS SPRING

(ALTERNATE ONLY) D2807-3
BOTH ENDS

D2807-041 GAS SPRING

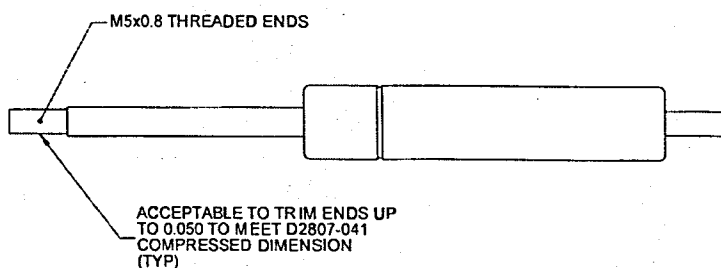
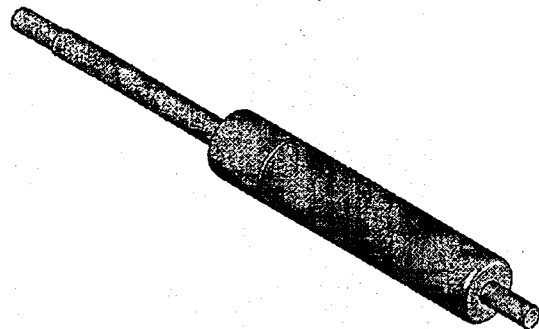
D2807-041 GAS SPRING ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D2807-041	GAS SPRING ASSEMBLY
1	D2807-5	GAS SPRING
1	D3671-1	PLACARD

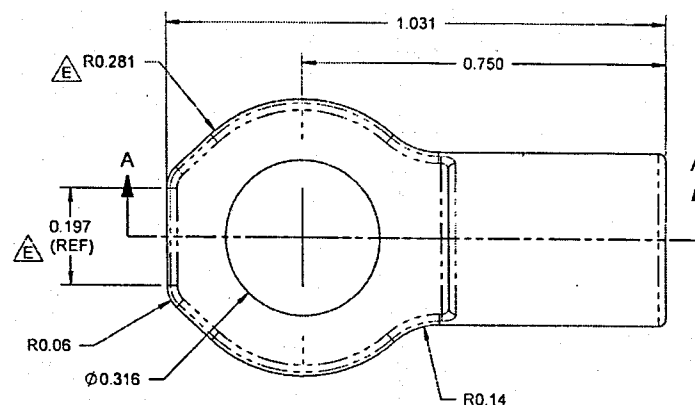
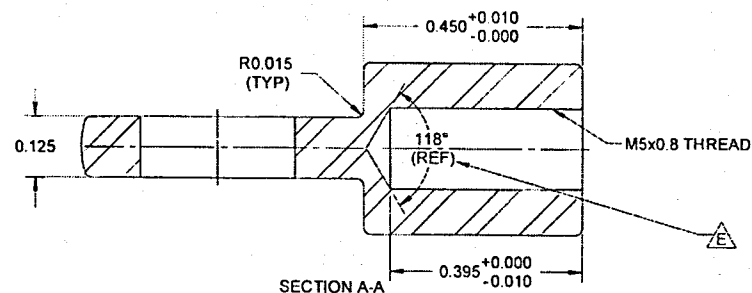
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) ALTERNATE PART: D2807-5 CAN BE MADE FROM ASSEMBLING D2807-1 (1) AND D2807-3 (2)
(WEIGHT: 0.176 LBS)

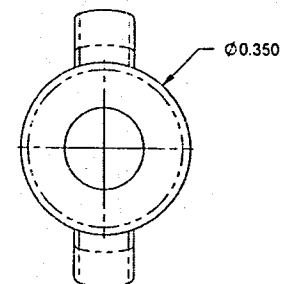
REV	DESCRIPTION	BY	DATE
E	ADD D2807 5 GAS SPRING D2807-1/-3 ASSEMBLY IS AN ALTERNATE TO D2807-5 GAS SPRING. UPDATE DIMENSIONS ON D2807-3	PH	07 12 28
D	ADDED D3671-1 PLACARD ADDED -041 ASSEMBLY UPDATED DWG	DC	07 09 27
C	CHANGE SPRING TO SS, ADD -3 LUG	CP	05 05 25
B	ADD FINISH	CP	05 03 16
A	NEW ISSUE	DS	00 11 03
DESIGN	DATE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CHECKED	DRAWING NO.	REV. E
MFG APPR	APPROVED	D2807	SHEET 1 OF 3
DE APPR	DATE	TITLE	SCALE
	07.12.28	GAS SPRING	NTS
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D2807-1 GAS SPRING
SCALE 1:1



D2807-3 LUG



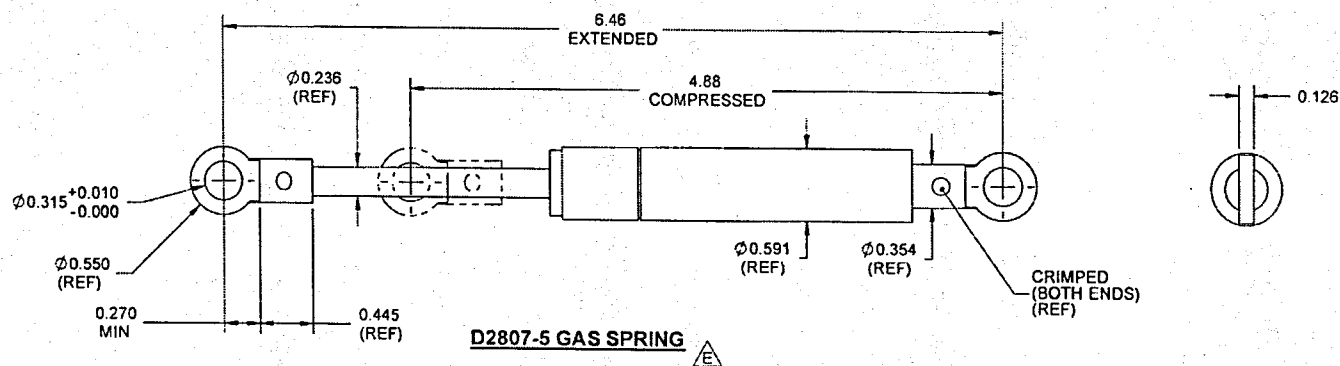
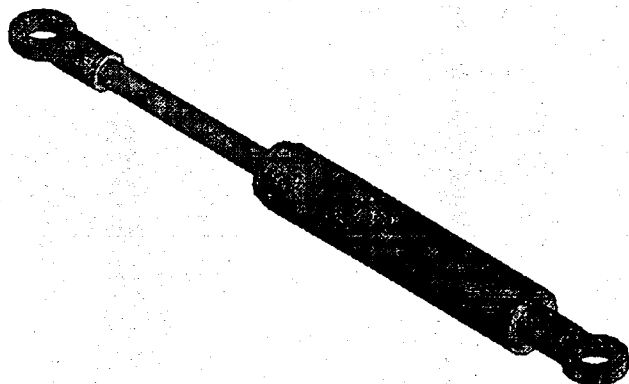
D2807-1 GAS SPRING NOTES:

- 1) POSSIBLE SUPPLIER: ARVINMERITOR MOTION CONTROL SYSTEMS, LEICESTER, UK
(P/N SXFGS6050080S6L-115N)
(REF: 80MM LONG CYLINDER, 50MM STROKE, 115N LOAD)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.144 LBS
- 8) SPECIFICATION: SS GAS SPRING
ACCEPTABLE LOAD RANGE IS 25 LB (115 N) MIN TO 45 LB (200 N) MAX
M5x0.8 THREADS

D2807-3 LUG NOTES:

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.015
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.016 LBS

DESIGN	HA	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. E
MFG. APPR.	LE	D2807	SHEET 2 OF 3
APPROVED	HA	TITLE	SCALE
DE APPR	HA	GAS SPRING	4:1
DATE	07.12.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD	
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D2807-5 GAS SPRING NOTES:

- 1) POSSIBLE SUPPLIER: LIFT SUPPORT TECHNOLOGIES, SASKATOON, CANADA (P/N 6/15-164/50-115N)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.169 LBS
- 8) SPECIFICATION: SS GAS SPRING WITH END FITTINGS, ACCEPTABLE LOAD RANGE 25 LB (115 N) MIN TO 45 LB (200 N) MAX

DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED	KE	DRAWING NO. D2807	REV. E
MFG. APPR.	KE	TITLE GAS SPRING	SHEET 3 OF 3
APPROVED	KE	SCALE 4:1	
DE APPR.	KE		
DATE	07.12.28	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPERTY AND CONFIDENTIAL AND IS NOT TO BE LOANED, REPRODUCED, COPIED, OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION OF DART AEROSPACE LTD	

LS Technologies Inc
314 Jessop Ave
Saskatoon, SK S7N 1Y6

Ph: 306-683-5000 Fax: 306-683-6403

Packing Slip

P.O. No.	Date	Invoice #
33138	8/24/2016	15304

Bill to:
Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

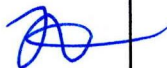
Ship to:
Main Finished Goods Location Dart Aerospace Ltd 1270 Aberdeen St. Hawkesbury, ON K6A 1K7

Ship	Via	FOB
7/26/2016	Fed-Ex	

Qty	Description
30	D2807-041 B149206 Stainless Gas Spring (6/15-164/50-115N)
	Shipping - UPS - Tracking # 1ZV659Y21460577127

8/25/16
SC

Order checked by :





LS Technologies Inc
314 Jessop Ave
Saskatoon, SK, S7N 1Y6
Ph: (306) 683-5000 Fax: (306) 683-6403

Certificate of Conformance

Aug 24, 2016

This is to certify that the parts listed below meets specifications as required by your order.

30 Units : D2807-041 B149206 Stainless Gas Spring (6/15-164/50-115N)

Country of Manufacture : Canada

Date of Manufacture : Aug 2016

This product is ROHS compliant.

Purchase Order # 33138

Inv# 15304

L S Technologies Inc Canada

A blue ink signature of Nolan Fehr, written over a horizontal line.

Nolan Fehr
President



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO33138

Purchase Order Date 7/22/2016

PO Print Date 7/22/2016

Page Number 1 of 2

Order From :

LS TECHNOLOGIES INC.
314 JESSOP AVE
SASKATOON, SK S7N 1Y6
CA

VC-LST0001

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 306 683 5000

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB EXW - (Ex Works)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	6/15-164/50-115N per drwg D2807 Rev.E B149206 staggered deliveries acceptable	Gas Spring	8/19/2016 Yes 8/19/2016		105.00 Each <i>Rec'd 36 8/25/16 SY</i>	\$63.90	\$6,709.50
						<i>Order 75X SP16-7-27</i>	
						Line Total:	\$6,709.50
2	71401-45 Procurement Quality Clauses		7/22/2016 No 8/19/2016		1.00	\$0.00	\$0.00
Procurement Quality Clauses A004 faa-pma/tso A005 right of entry A016 personnel qualification A025 certification of conformance A040 notification of quality escape A043 retention of quality document							

PO Instructions: Fedex Acc#151793240

Note:

7/22/2016